

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017047**Date Inspected:** 15-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Shi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 12, Light Bracket (NWIT # 06677)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

LB3A-002-007, 008, 009, 010

LB3A-003-004, 005, 007, 008, 009, 010

LB4A-002-007, 008

**ULTRASONIC TESTING**

OBG SEGMENT 10AE-10BE

ABF Request No: 09142010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT

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Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the Side Panel(SP) to Edge Panel(EP) holdback areas (BK side) weld of OBG segment 10AE and 10BE. The weld designations were as follows:

CA072-001

CA076-005

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 14, 13AE-BP3032-001

During random in process inspection this QA inspector observed that ABF NDT personnel was performing Magnetic Particle Testing (MT) on the temporary attachment removed area of base metal of BP3032-001 (PL3220C & PL 3221C). The members are identified as OBG components.

BAY 16, BOTTOM PLATE (HSR-9336)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joint of bottom plate of 13AW. The members are identified as OBG components and the weld designations reviewed are as follows.

BP3056-001-002

STEEL BARRIER (W5-SB13)

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up by using Shielded Metal Arc Welding (SMAW) process for steel barrier W5-SB13. Welder is identified as 201905. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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